

# Work Order ID 83566

**\*83566\***

Page 1

Thursday, April 19, 2012 3:38:43 PM

Item ID: D350-604-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rear Locker Extender

Start Date: 4/19/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/18/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: 12-01-19

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2273

*REF*  
B *[Signature]*

D350-604-041

B

100

**\*100\***

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and create labels per PPP D350-604-041 CHG004

0.00

0.00

*DAS 16*

*alake*

*[Signature] 12-9-28*

110

**\*110\***

Purchasing

Purchasing

PURCHASING

Memo

Issue P/O: 16795  
Description: D350-604-041 Rear locker extender.  
Supplier: Delastek.  
Certification of Conformity and process sheet from Delastek is required.

0.00

0.00

*17636*

*OK 12/04/23 ①*

*12/09/12 ①*

4 x 2600-6 Camlock stud - Ship to Delastek B

4 x 2600-LW Retaining washers - Ship to Delastek B

*121287 122335*  
*121524*

*#33*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 83566****\*83566\***

Page 2

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

Receive &amp; Inspect for Damage &amp; Mat'l Certs

0.00

**\*120\***

Packaging

Packaging

Memo

0.00

Ensure a copy of Certification of Conformity and process sheet from Delastek is attached.

130

QC5- Inspect part completeness to step on W/O

0.00

**\*130\***

QC

Quality Control

Memo

0.00

Check hole locations to template. DT 8824 Check process sheet and audit.

140

0.00

**\*140\***

Small Fab

Small Fab

Memo

0.00

INSTALL DECALS AS PER DWG

W/O: 83566		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

See pink 12-1868

Part No: D350-604-041 PAR #: \_\_\_\_\_ Fault Category: Suplus NCR: Yes No DQA: [Signature] Date: 12/16/03  
 Resolution: \_\_\_\_\_ Disposition: Re work QA: N/C Closed: [Signature] Date: 12/16/04

NCR: 12-1867		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/9/24	120	Found @ inspection that the Primer is cracking and chipping off. Re. Parts were not seal-leakproof by suplus	<u>DAS</u> 16 9-83 Q57042 12/05/24	Remove all Primer + Scuff to have proper Adhesive. Re Prime As Per DWG + Q57004	<u>AD</u> 12-9-27	<u>(DAS)</u> 16 9-83 12/05/24	<u>DAS</u> 16 9-83 Q57042 12/05/24	
		Solve Supplier						

NOTE: Date & initial all entries

**Work Order ID 83566****\*83566\***

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Thursday, April 19, 2012 3:38:43 PM

Item ID: D350-604-041

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rear Locker Extender

Start Date: 4/19/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 5/18/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150

QC5- Inspect part completeness to step on W/O

0.00

**\*150\***

QC

Memo

0.00

Quality Control

160

Packaging

0.00

**\*160\***

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-604-041

Location: 3PPP Rev: I

170

QC21- Final Inspection - Work Order Release

0.00

**\*170\***

QC

Memo

0.00

Quality Control

DAS  
16  
12/02/28

1X

SP  
12-9-28

12/10/11

mf  
12-10-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Thursday, April 19, 2012 3:38:47 PM

**\*83566\***

**\*D350-604-041\***

**Required Date:** 5/18/2012

**Required Qty: 1.00**

IPP REV:R  
IPP REV:S 12.04.04

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2269		Manufactured	No				Each	28.0000		1			
<p><b>*D2269*</b></p> <p>Decal</p>													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST007				20					
					80011			20					
				ST009				8					
					78920			8					
2600-6		Purchased	No			110	Each	131.0000	4	4			
<p><b>*2600-6*</b></p> <p>Camlock Stud</p>													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST380				36					
					120077			36					
				ST381				95					
					121287			95					
2600-LW		Purchased	No			110	Each	111.0000	4	4			
<p><b>*2600-LW*</b></p> <p>Camloc Retaining Washer</p>													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST381				100					
					121287			100					
				ST398				11					
					120648			11					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Page 2

Thursday, April 19, 2012 3:38:47 PM

Work Order ID: 83566

**\*83566\***

Parent Item: D350-604-041

**\*D350-604-041\***

Parent Item Name: Rear Locker Extender

Start Date: 4/19/2012

Required Date: 5/18/2012

Start Qty: 1.00

Required Qty: 1.00

D350-604-041P

Purchased

No

110

Each

0.0000

1

1

**\*D350-604-041P\***

**\*\***

Rear Locker Extender

D2268

Manufactured

No

140

Each

33.0000

1

1

**\*D2268\***

**\*\***

Decal

*sf 12/9/08*

Location

Loc Qty

Loc Code

ST007

20

80010

20

ST009

13

69592

2

78908

11

Thursday, April 19, 2012 3:38:47 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

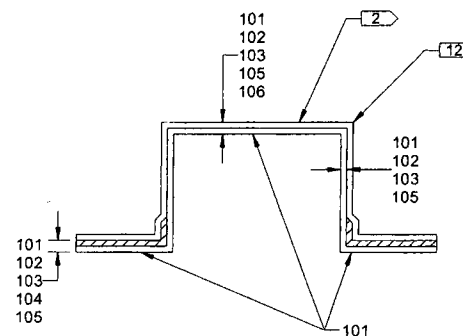
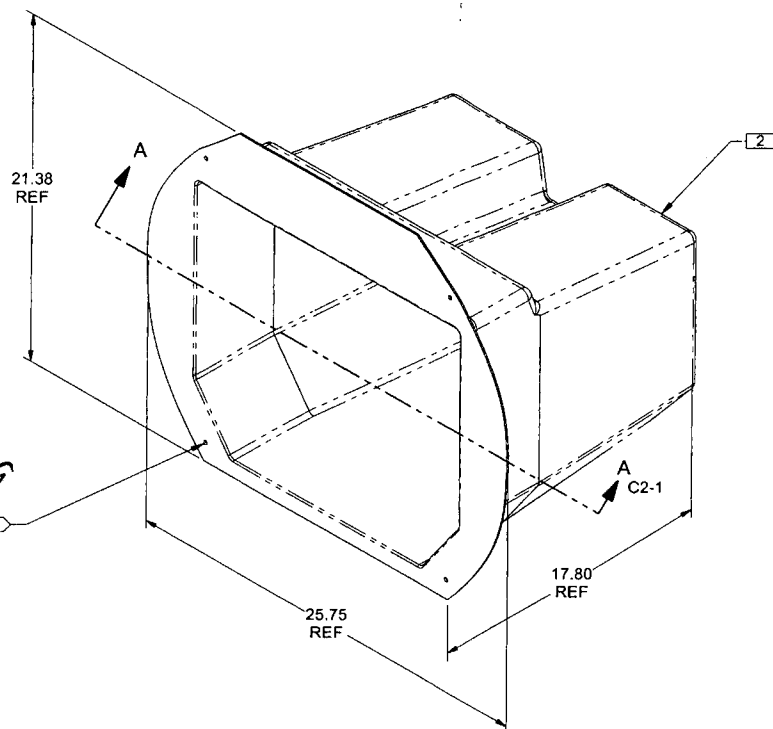
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 83566  
112-04-19



SECTION A-A  
C4-1

RELEASED  
2012-03-29

NOTES:

1) MATERIALS:

RESIN: DERAKANE 470-36/411/510A40  
FIBRE: 9 oz = 9.7 oz 7781 WEAVE "S" GLASS  
18 oz = 18.0 oz ROVING "E" GLASS

2) FINISH: FINISH THIS SURFACE WITH DUPONT GREY PRIMER LE 3404-S/LE 1175-S  $\Delta$

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1

7) WEIGHT: 7.75 lbs

8) LAMINATE PER DART QSI 006. LAMINATION SCHEDULE PER THIS DRAWING.

9) LAYUP USING DT8010 MOLD. WET LAYUP NO BAG/VACUUM

10) TRIM & DRILL PER DT8020. OPEN HOLES TO  $\varnothing$ 0.257 (4 PLACES)

11) CONSTRUCTION:

101-WHITE GLOSS GELCOAT # GEL 2330PAWK745 TO MIN THICKNESS OF 0.020

102-9 oz ALL OVER

103-18 oz ALL OVER

104-18 oz REINFORCE FRONT FLANGE EXTENDING 2" ON SIDES

105-9 oz ALL OVER

106-PEEL PLY

12) MATTE TO HOLD DOWN CORNERS AS REQUIRED

**D2273 REAR LOCKER EXTENDER**

F	PRIMER LE 3404-S/LE 1175-S WAS 1144-S, ZN A6-1	DC	12.02.27
E	CHANGED SURFACE FINISH FROM 944W005 GELCOAT TO 2330PAWK745 GELCOAT, ZN A7-1. UPDATED DWG TO CURRENT STANDARDS.	DC	12.02.02
D	REMOVE EPOCAST, ADD SURFACE FINISH	CP	02.04.01
C	CLARIFY MATERIAL, LAYUP, AND TOOLING	RF	02.01.30
B	RE-DRAWN	MM	98.05.27
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED	BE	DRAWING NO.	REV. F
MFG. APPR.	BE	<b>D2273</b>	SHEET 1 OF 1
APPROVED	SA	TITLE	SCALE
DE APPR.	SA	<b>350 REAR LOCKER EXTENDER</b>	NTS
DATE	12.02.27	<small>COPYRIGHT © 1986 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Linda Lacelle

---

**From:** dshepherd@dartaero.com  
**Sent:** April-03-12 1:38 PM  
**To:** Daniel Campbell; 'Linda Lacelle'  
**Cc:** Harvey Siemens; Chantal Lavoie  
**Subject:** Re: ECN D2273

Dan,

I think Delastek is confused. Leave the dwgs for now ... I don't care whether we use Rev E primer or Rev F primer ... My understanding is that your Rev F dwg represents what is procurable going forward.

David

Sent from my BlackBerry device on the Rogers Wireless Network

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**From:** "Daniel Campbell" <[dcampbell@dartaero.com](mailto:dcampbell@dartaero.com)>  
**Date:** Tue, 3 Apr 2012 10:42:39 -0600  
**To:** 'Linda Lacelle' <[llacelle@dartaero.com](mailto:llacelle@dartaero.com)>; <[dshepherd@dartaero.com](mailto:dshepherd@dartaero.com)>  
**Cc:** Harvey Siemens <[hsiemens@dartaero.com](mailto:hsiemens@dartaero.com)>; Chantal Lavoie <[clavoie@dartaero.com](mailto:clavoie@dartaero.com)>  
**Subject:** RE: ECN D2273

Hi,

I'm a little confused about this.

I thought we had checked back in Feb. and the 7704-S was discontinued and replaced with LE-3404-S / LE1175-S ?

Anyway, I can go back and update the following to call out 7704-S:

D604-350

1. D2273
2. ICA-D350-604

D605-206

1. D2566
2. ICA-D605-206

I'm not sure if David is flying today - we might have to wait for him to weigh in.

Thanks,

Dan

**From:** Linda Lacelle [<mailto:llacelle@dartaero.com>]  
**Sent:** April-03-12 10:00 AM  
**To:** [dshepherd@dartaero.com](mailto:dshepherd@dartaero.com); Daniel Campbell  
**Subject:** FW: ECN D2273

**From:** Jocelyne Laurin [<mailto:JLaurin@delastek.com>]  
**Sent:** April-03-12 11:30 AM  
**To:** Linda Lacelle  
**Cc:** 'Chantal Lavoie'; Céline Audet  
**Subject:** ECN D2273

Hello Linda,

For the Gel Coat we are presently using N° 2330PAWK745, Gel Coat Polycore Fireblock and for the primer Dupont Primer N° 7704S. Thank you and have a nice day.

*Jocelyne Laurin*

Agente Service à la clientèle/Customer Service Agent

**DELASTEK INC.**

[jlaurin@delastek.com](mailto:jlaurin@delastek.com)

**De :** Linda Lacelle [<mailto:llacelle@dartaero.com>]

**Envoyé :** 2 avril 2012 14:54

**À :** Jocelyne Laurin; 'Chantal Lavoie'

**Cc :** David Paradis; Céline Audet

**Objet :** RE: ECN D2273

**Importance :** Haute

Jocelyne,

This is the current primer you are using. We need to understand exactly what you are currently using. Please DO NOT stop production on the parts to ship this Thursday.

L

**From:** Jocelyne Laurin [<mailto:JLaurin@delastek.com>]

**Sent:** April-02-12 10:18 AM

**To:** 'Chantal Lavoie'; Linda Lacelle

**Cc:** David Paradis; Céline Audet

**Subject:** ECN D2273

**Importance:** High

Hello Chantal,

Before we can ship the rearlockers at rev. F, (for order attached), we have to analyse the implications, so the confirmed dates no longer stand, since they were for revision E. As soon as the analysis is completed we will forward a new quote (if applicable) as well as the new delivery dates, unless you want them at Rev. E. Please advise ASAP as they are being produced at the moment. Thank you so much and have a nice day.

*Jocelyne Laurin*

Agente Service à la clientèle/Customer Service Agent

**DELASTEK INC.**

[jlaurin@delastek.com](mailto:jlaurin@delastek.com)

**De :** Chantal Lavoie [<mailto:clavoie@dartaero.com>]

**Envoyé :** 30 mars 2012 10:38

**À :** Jocelyne Laurin

**Cc :** Lacelle, Linda

**Objet :** ECN D2273

Hi Jocelyne,

Please see attached for new revision for rearlocker they are now at rev. F.

Thanks

Chantal

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No virus found in this message.

Checked by AVG - [www.avg.com](http://www.avg.com)

Version: 2012.0.1913 / Virus Database: 2114/4912 - Release Date: 04/03/12



## Certificate of Conformance

**Solve Composites**

**29 Distribution Way**

**Plattsburgh, New York, 12901**

**USA**

**Dart Aerospace Order Number: 17636**

**Part Number: D2273**

**Quantity: 1**

**Drawing Number: D2273, DT8020**

**Serial Number (s): 0030, 0031, 0032, 0033, 0034**

**Date: September 24, 2012**

**Non-Conformances: None**

**This is to certify that the parts identified above conform to all applicable drawings and/or specifications as evidenced by reports on file, and that all other purchase order and quality requirements have been met.**

**Jerry Reyell**

**Project Manager**

**Solve Composites**